



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3594-043
Job Sheet 170690



①

Part No: D3594-043

Job Qty: 8 ea

Part Name: Floor Doubler Assembly, LH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/18/18

Job Tracking No:

Due Date: 1/23/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV D SHEETS 3,4 IPP Rev :A New Issue 07-01-22 EC IPP REV:B 16.07.28 DWG REV:C DD
VERF:JLM IPP REV:C 17.04.27 AS PER DWG REV.D DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	8 Ea	1/22/18	1/22/18	0.00	0.00	Start Up Waterjet		SC 18/01/22
100	Waterjet	8 pcs	1/22/18	1/22/18	0.00	3.31	Waterjet1		SC 18/01/22
110	QC	8 pcs	1/22/18	1/22/18	0.00	0.00	QC2 Waterjet-2		SC 18/01/22
120	QC	8 pcs	1/22/18	1/22/18	0.00	0.00	QC8-3		38
130	Small Fab	8 pcs	1/22/18	1/22/18	0.00	0.42	Small Fab-4		9-89
140	QC	8 pcs	1/22/18	1/22/18	0.00	0.00	QC5		
150	HandFinish	8 pcs	1/22/18	1/22/18	0.00	0.27	HandFinish1		2018/01/25 JSC
160	QC	8 pcs	1/22/18	1/22/18	0.00	0.00	QC7-2		2018/01/25 JSC
170	Small Fab	8 pcs	1/23/18	1/23/18	0.00	0.42	Small Fab-4		DAS 38 DAS
180	QC	8 pcs	1/23/18	1/23/18	0.00	0.00	QC5		38 DAS
190	Packaging	8 pcs	1/23/18	1/23/18	0.00	0.00	Packaging3-1		51523 JAN 30 2018
200	QC21-SA	8 Ea	1/23/18	1/23/18	0.00	0.00	QC21		9-89 21 JAN 30 2016

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.080	6061-T6 .080 Sheet	4.0800 sf (.51 ea)	90-Start up Operation	
MS21069-5	Anchor Nuts	8 Ea (1 ea)	130-Small Fab	5024474 6x FM137587 2x
MS20426AD4-4	Rivet	16 Ea (2 ea)	170-Small Fab	F-125445-4

5023289 5.3

M138162 ①

Part Specifications

Specifications could not be found.

Plex 1/18/18 1:04 PM dart.lacelle.linda

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS							
	Rework	☐	Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐
	Scrap	☐	Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐
	Use-as-is	☐	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
	Suspected Unapproved	☐	Large Fab	☐	Composite	☐	Supplier	☐		

Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
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Description Work Order Deviation

Job No: 170690
Start up Operation 01/22/18

Change No:
Operation:
Revision:
Original Serial #: S034272
PART NO: D3594-043

Floor Doubler Assembly, LH



S034272
DART
AEROSPACE

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Root Cause													
Environment	☐	No Re-verification	☐	Pressure/Force	☐		☐		☐		☐		☐
Design	☐	Operator	☐	Bending	☐		☐		☐		☐		☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Co	☐		☐		☐		☐		☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐		☐		☐		☐		☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Rip	☐		☐		☐		☐		☐
Material	☐	Use for Testing	☐	Cuffs	☐		☐		☐		☐		☐
Internal Transport	☐	Poor Information	☐	Crushing	☐		☐		☐		☐		☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐		☐		☐		☐		☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐		☐		☐		☐		☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐		☐		☐		☐		☐
Past Expiry Date	☐	Manufacturing Process	☐		☐		☐		☐		☐		☐
Misidentified	☐	Past Due	☐	OTHER :	☐		☐		☐		☐		☐

Completed By

Lead / Supervisor
al VerificationCoordinator
approval

Lead Wrong
Dimensions
Tolerance
Correct
Missing

Part Moved

Drawing

Finish

Misread

Turning Sequence

Off-set

Misabeled

Fit/Function

Misaligned/off center

DART AEROSPACE LTD		Work Order: 170690
Description: Floor Driveler Assembly, LH		Part Number: D3594-043
Inspection Dwg: 3594	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 9,128	+0,005 - 0,001	Ø 9,128	1		VDC-01	
Ø 0,323	+0,006 - 0,001	Ø 0,323	1		VDC-02	
0,359	+/- 0,010	0,358	7		Tape	
0,718	+/- 0,010	0,716	1			
0,81	+/- 0,030	0,819	1			
2,58	+/- 0,030	2,584	1			
2,688	+/- 0,010	2,687	1			
7,563	+/- 0,010	7,565	1			
7,85	+/- 0,030	7,849	1			
11,77	+/- 0,030	11,779	1			
12,75	+/- 0,030	12,75	1			
0,080	+/- 0,010	0,079	1			

Measured by: SC	Audited by: DAS 38	Preliminary Approval:
Date: 18/01/27	Date: JAN 24 2020	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	